

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008953**Date Inspected:** 05-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

1AE

FCAW welding of weld joint 003 located on SSD34-PP8.5.

Welder is identified as Mr. Yun Chuanshan (050316). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-FCM and repair procedure CWR700.

FCAW welding of weld joint 003 located on SSD34-PP8.5.

Welder is identified as Mr. Ji Hongwei (058245). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U4b-FCM and repair procedure CWR700.

1AAE & 1AE

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SMAW welding of base metal on both sides of weld joint 001 located on OBE1-001.

Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair-1.

SMAW welding of base metal on both sides of weld joint 003 located on OBE1-001 located on bike path side of segment. Welder is identified as Mr. Zang Yanbo (045196). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair-1.

1BE

SMAW welding (repair) on side plate stiffeners at panel point 12.5 (bike path and cross beam).

Welder is identified as Mr. Ge Hongqi (048659). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G (2F)-FCM-Repair-1.

5BE

FCAW welding of weld splice joints 046~048 located on SP603B.

Welder is identified as Mr. Li Shuqiang (053609). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232.

SMAW welding of weld splice joints 014~018 located on DP630A-001.

Welder is identified as Mr. Bi Shijian (068764). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2114-FCM-1.

5CE

FCAW welding of weld splice joints 010~012 located on SP604A.

Welder is identified as Mr. Li Shuqiang (053609). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232.

SMAW welding of weld splice joints 007~012 located on DP631A-001.

Welder is identified as Mr. Bi Shijian (068764). ZPMC QC is identified as Li Jia.

The welding variables recorded by QC appeared to comply with WPS-B-T-2114-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

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Inspected By:	Alaniz,Joe	Quality Assurance Inspector
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Reviewed By:	Carreon,Albert	QA Reviewer
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